

P a t e n t c l a i m s

1.

A marine flooring plate designed for use as walking base in a boat, which marine flooring plate is constructed of a High Pressure Laminate (HPL) having a body of kraft paper (P) impregnated with thermosetting binding agent, an upper layer in the form of a décor paper (D) imprinted with wood structure and impregnated with resin and a wear resistant top layer in the form of a transparent paper (O) impregnated with resin, **characterized in that** the body of the high pressure laminate has a through inked black or brown core, that the wear resistant top layer and the upper layer having wood structure décor is machined in the depth (d) and into the black/brown core of the high pressure laminate by means of a milling tool to form seams (3, 4) in the marine flooring plate in a predetermined pattern to imitate a marine flooring of natural wood having seams.

2.

The marine flooring plate according to claim 1, **characterized in that** the high pressure laminate consists of approximately 60% paper and approximately 40% thermosetting binding agent.

3.

The marine flooring plate according to claim 1 or claim 2, **characterized in that** the core of the high pressure laminate is impregnated with phenolic resin.

4.

The marine flooring plate according to claim 1, 2 or 3, **characterized in that** the décor paper (D) is impregnated with melamine resin.

5.

The marine flooring plate according to any of the claims 1-4, **characterized in that** the top layer (O) is impregnated with melamine resin.

6.

The marine flooring plate according to any of the claims 1-5, **characterized in that** the machining depth (d) to form the seams (3, 4) is in order of magnitude 0,1 to 1,0mm.

7.

The marine flooring plate according to any of the claims 1-6, **characterized in that** the machining width to form the seams (3, 4) is in order of magnitude 3 to 10mm.

8.

A method for manufacture of a marine flooring plate designed for use as walking base in a boat, which marine flooring plate is constructed of a High Pressure Laminate (HPL) having a body of kraft paper impregnated with thermosetting binding agent, an upper layer in the form of a décor paper imprinted with wood structure and impregnated with melamine resin and a wear resistant top layer in the form of a transparent paper impregnated with melamine, said body of the high pressure laminate has a through inked black or brown core, **characterized in that** the wear resistant top layer and the upper layer having wood structure décor are depth machined and down into the black/brown core of the high pressure laminate by means of a milling tool to form seams in the marine flooring plate in a predetermined pattern to imitate a marine floor of natural wood having seams.

9.

A method according to claim 8, **characterized in that** the milling tool is connected to a numeric controlled machine tool (CNC) having an option for programming of actual patterns of marine flooring plates.

10.

A method according to claim 8 or 9, **characterized in that** a standard high pressure laminate plate initially is fixed on stable jigs by means of vacuum and is positioned relative to the milling tool and seams are milled in the plate to depths in order of magnitude 0,1 to 1,0mm.

11.

A method according to any of the claims 8-10, **characterized in that** the milling tool is arranged to take into account variations in thickness and curving of the plate by means of proximity sensors.